



Dart Aerospace Ltd.
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Canada

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D3913-041

Job Sheet 198562



Part No: D3913-041

Job Qty: 1 pcs

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/31/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 9/9/19

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	9/9/19	9/9/19	0.00	19.61	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3	DAS	
							Large Fab - 4	24	
							Large Fab - 5	9-89	
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
110	QC 9	1 pcs	9/9/19	9/9/19	0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24	DAS	
							QC 9 - 43	43	
							QC 9 - 50	9-89	
							QC 9 - 9		
120	QC 5	1 pcs	9/9/19	9/9/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3	DAS	
							QC 5 - 43	43	
							QC 5 - 49	9-89	
							QC 5 - 51		
							QC 5 - 58		



Container No: S218916



Part: D3913-041

Job No: 198562

Serial No/Batch: S218916

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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Date: 10/01/19

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7/31/2019

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						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
125	Handfinish - 2-1 Pressure- B4B	1	9/9/19	0.00	0.29	Handfinish - 2 - 1 - B4B	BER 19-10-03
	pcs					Handfinish - 2 - 2 - B4B	
						Handfinish - 2 - 3 - B4B	
						Handfinish - 2 - 4 - B4B	
130	Powdercoat - 2 White Gl(S)- B4B	1	9/9/19	0.00	0.93	Powdercoat - 1 - B4B	
	pcs					Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	BL 19-10-4
						Powdercoat - 4 - B4B	
140	QC 3	1	9/9/19	0.00	0.00	QC 3 - 10	
	pcs					QC 3 - 13	
						QC 3 - 15	ML 19-10-4
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
150	Handfinish - 4-1-Assembly- B4B	1	9/9/19	0.00	0.50	Handfinish - 4 - 1 - B4B	ML 14-10-4
	pcs					Handfinish - 4 - 10 - B4B	
						Handfinish - 4 - 11 - B4B	
						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 - B4B	
						Handfinish - 4 - 4 - B4B	
						Handfinish - 4 - 5 - B4B	
						Handfinish - 4 - 6 - B4B	
						Handfinish - 4 - 7 - B4B	
						Handfinish - 4 - 8 - B4B	
						Handfinish - 4 - 9 - B4B	
160	QC 5	1	9/9/19	0.00	0.00	QC 5 - 10	

DAS
15
9-89

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		pcs				QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	DAS
						QC 5 - 40	81
						QC 5 - 61	9-89
						QC 5 - 81	
170	Packaging 3-1 - Stock - B4B	1	9/9/19	0.00	0.00	Packaging 3 - 1 - B4B	HL 14-10-4
		pcs				Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 - B4B	
						Packaging 3 - 33 - B4B	
						Packaging 3 - 34 - B4B	
						Packaging 3 - 35 - B4B	
						Packaging 3 - 36 - B4B	
180	QC 21 - SA	1	9/9/19	0.00	0.00	QC 21 - SA - 21	DAS
		pcs				QC 21 - SA - 70	21
						QC 21 - SA - 53	9-89

Part Op 100 - Weld per dwg A/R S.S. rod Batch: 139015 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect
 Descriptions: before welding mesh*** 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to

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fit if necessary and trim to clear fasteners holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913
 take lid to locate hinge and bracket 4- Weld D4672-1 blanking plates as per dwg

110 - QC9- Inspect visual per QSI004- Fusion Welds

120 - QC5- Inspect part completeness to step on W/O

125 - Pressure Wash per QSI005 4.3/ Clean and remove all markings

130 - White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel) 1- Plug holes and mask only interior of hinge (3) prior to powder coat

140 - QC3- Inspect Part Finish

150 - Assemble as per dwg - Pick Kit

160 - QC5- Inspect part completeness to step on W/O

170 - Identify as per dwg & Stock Location: _____

180 - QC21- Final Inspection - Work Order Release

012104

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5211340
D3913-1	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5215071
D3913-15	Wide Handle Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	5104576
D3913-3	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5209258
D3913-7	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	52114637
D3913-9	Hinge Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5210802
D3916-041	Rib Assembly	2 pcs (2 ea)	100-Large Fab - Basket - 1	5214262
D3916-5	Light Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	5211960
D4016-1	Hinge Half, Base	3 pcs (3 ea)	100-Large Fab - Basket - 1	5213515
D4017-7	Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	5212014
D4017-9	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5214695
D4020-11	End Mesh, Basket	2 pcs (2 ea)	100-Large Fab - Basket - 1	521073
D4021-1	Handle Plate	3 pcs (3 ea)	100-Large Fab - Basket - 1	5210384
D4034-041	Aft Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	5216390
D4034-043	Fwd Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	5216456
D4672-1	Blanking Plate	2 pcs (2 ea)	100-Large Fab - Basket - 1	5210714
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	100-Large Fab - Basket - 1	5206468
AN3-10A	Bolt 5205294(x1)	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	5212401-1
D2931	Bumper	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	F86435
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5216674
MS21042L3	Nut	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	5204783-2
NAS1149F0332P	Washer (AN960-10L)	12 Ea (12 ea)	150-Handfinish - 4-1-Assembly-B4B	5207309
D4021-5	Blanking Plate	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5188989
NAS1149FN832P	Washer (AN960-8)	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5136368

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	56	0
	D3913-1	1	6	0
	D3913-15	1	20	0
	D3913-3	1	6	0
	D3913-7	2	14	0
	D3913-9	1	9	0
	D3916-041	2	2	0
	D3916-5	3	8	0
	D4016-1	3	28	0
	D4017-7	3	40	0
	D4017-9	2	12	0
	D4020-11	2	6	0
	D4021-1	3	28	0
	D4034-041	1	2	0
	D4034-043	1	8	0
	D4672-1	2	7	0
	M304EX0.75-16F	32	561	0
	AN3-10A	6	142	0
	D2931	2	687	0
	D4021-5	2	32	0
150-Handfinish - 4-1-Assembly-B4B	MS20600-AD4W3	2	880	0
	MS21042L3	6	856	0
	NAS1149F0332P	12	2,290	0
	NAS1149FN832P	2	1,764	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QSI042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
Bending	Misaligned/off center	Folio/Program	Outside Tolerance
Crushing	BOM/Route	Grain Direction	Drawing
Cracks	Broken/Damage/Defect	Weld	Finish
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing
Marks/Chatter	Drill Holes	Out of Sequence	Misread
Mislabeled	Fit/Function	Off-set/Set-up	

Other/Details: _____